

Work Order ID 134407

134407

Page 1

Wednesday, July 08, 2015 3:13:06 PM

Item ID: D3456-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Washer

Stop *NS2*

Start Date: 7/04/15

Start Qty: 25.00

~~*25*~~

Cust Item ID:

Required Date: 7/07/15

Req'd Qty: 25.00

~~*25*~~

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: JUL 09 2015

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3456

Rev A

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 29071 P/N: 91525A120 per Dwg D3456Possible
Supplier: McMaster-CarrMaterial release note is required

100 JUL 10 2015 CL

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.01

Packaging

Ensure Material Release Note is attached

100x 8015-07-13

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

100

DAS
38
9-89

JUL 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected-Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large-Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 134407***134407***

Page 2

Wednesday, July 08, 2015 3:13:06 PM

Item ID: D3456-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Washer

Start Date: 7/04/15

Start Qty: 25.00

25

Cust Item ID:

Required Date: 7/07/15

Req'd Qty: 25.00

25

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ST038A

0.00

130

Packaging

Memo

0.00

DAS
6
9-89

(100)

JAJUL 14 2015

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.04

MLJJUL 14 2015

Quality Control

MLJJUL 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, July 08, 2015 3:13:05 PM

Page 1 /

Work Order ID: 134407

134407

Parent Item: D3456-1

D3456-1

Parent Item Name: Washer

Start Date: 7/04/15

Required Date: 7/07/15

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP A05.10.03New issueKJ/JLM

[illegible]

DQA: _____ Date: _____

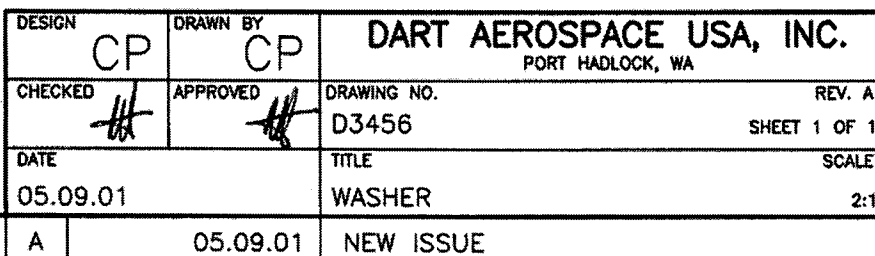


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

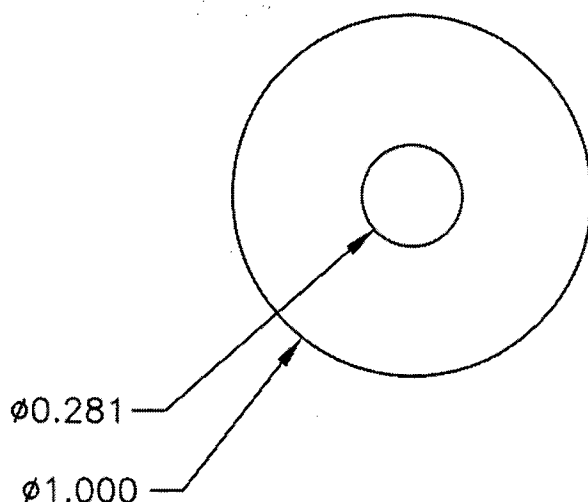
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐	☐	Positioned Wrong ☐															
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐	Folio/Program ☐	☐	Outside Dimensions ☐															
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐	Grain ☐	☐	Over/Under tolerance ☐															
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐	Weld ☐	☐	Part Incorrect ☐															
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐	☐	Part Lost/Missing ☐															
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐	Out of Sequence ☐	☐	Part Moved ☐															
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐	Off-set ☐	☐	Drawing ☐															
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐	☐	Finish ☐															
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐	☐	Misread ☐															
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐	☐	Turning Sequence ☐															
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :																						
Misidentified ☐	☐	Past Due ☐																							



RELEASED
05-09-06

SPECIFICATION CONTROL DRAWING



D3456-1 WASHER

- 1) MATERIAL: 316 STAINLESS STEEL, 0.050" THICK
2) MAY PURCHASE McMASTER-CARR P/N 91525A120
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SLOP COPY
ATTN TO:
INTERMEDIATE
SECTION OF THE SLOP COPY
SLOP COPY OF THE MARY
STATE OF NEW YORK
1507-09

Copyright © 2005 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29071**

Purchase Order Date 7/9/2015

PO Print Date 7/10/2015

Page Number 9 of 10

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 10

Currency USD

FOB FCA - (Free Carrier)

27	71400-15	52375K13 PVC TUBING (25 FT)	7/13/2015	1.00	\$21.75	\$21.75
			Yes	Each		
			7/13/2015			

Line Total: \$21.75

Deliver To: LUC

29	91525A120	washer	7/13/2015	100.00 ✓	\$0.27	\$26.64
			Yes	Each		
			7/13/2015			

AS PER D3456 REV. A
B134407

8015-0713

Line Total: \$26.64

30	71401-45	PROCUREMENT QUALITY CLAUSES	7/13/2015	1.00	\$0.00	\$0.00
			No			
			7/13/2015			

PROCUREMENT QUALITY CLAUSES
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A025 CERTIFICATE OF CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Note:

7/10/2015

Packing List

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Luc / Andy

Purchase Order
PO29071

Order Placed By
Chantal Lavoie

McMaster-Carr Number
5807576-03

Page 2 of 2

07/10/2015

Line	Product	Ordered	Shipped
20	47865K22 Brass Ball Valve, 3/8" NPT Female Connections Your Part Number: 71400-15	7 Each	7 ✓
21	4568K154 Standard-Wall Brass Threaded Pipe Nipple, 3/8 Pipe Size X 2-1/2" Length Your Part Number: 71400-15	7 Each	7 ✓
22	4568K198 Standard-Wall Brass Threaded Pipe Nipple, 3/4 Pipe Size X 5" Length Your Part Number: 71400-15	3 Each	3 ✓
23	5346K19 Brass Barbed Hose Fitting, Adapter for 3/8" Hose ID X 3/8" NPTF Male Pipe, Packs of 5 Your Part Number: 71400-15	2 Packs	2 ✓
24	5346K24 Brass Barbed Hose Fitting, Adapter for 1/4" Hose ID X 3/8" NPTF Male Pipe, Packs of 5 Your Part Number: 71400-15	2 Packs	2 ✓
25	5346K18 Brass Barbed Hose Fitting, Adapter for 3/8" Hose ID X 1/4" NPTF Male Pipe, Packs of 10 Your Part Number: 71400-15	1 Pack	1 ✓
27	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25 Your Part Number: B134407	4 Packs	4 ✓

SP-07-B

McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 34204708
 Purchase Order: PO29071
 Release:
 McMaster-Carr Number: 5807576-03

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
18	4429K333 Low-Pressure Brass Threaded Pipe Fitting, 3/4 X 3/8 X 3/4 Pipe Size, Inline Reducing Tee 71400-15 Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	5 EA	\$13.60	\$68.00
19	4429K252 Low-Pressure Brass Threaded Pipe Fitting, 3/8 Pipe Size, Tee 71400-15 Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	3 EA	\$7.97	\$23.91
20	47865K22 Brass Ball Valve, 3/8" NPT Female Connections 71400-15 Country of Origin: Italy Schedule B #: 848180 ECCN #: EAR99 NLR	7 EA	\$8.27	\$57.89
21	4568K154 Standard-Wall Brass Threaded Pipe Nipple, 3/8 Pipe Size X 2-1/2" Length 71400-15 Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	7 EA	\$2.68	\$18.76
22	4568K198 Standard-Wall Brass Threaded Pipe Nipple, 3/4 Pipe Size X 5" Length 71400-15 Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	3 EA	\$8.72	\$26.16
23	5346K19 Brass Barbed Hose Fitting, Adapter for 3/8" Hose ID X 3/8" NPTF Male Pipe, Packs of 5 71400-15 Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	2 PK	\$8.73	\$17.46
24	5346K24 Brass Barbed Hose Fitting, Adapter for 1/4" Hose ID X 3/8" NPTF Male Pipe, Packs of 5 71400-15 Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	2 PK	\$10.07	\$20.14
25	5346K18 Brass Barbed Hose Fitting, Adapter for 3/8" Hose ID X 1/4" NPTF Male Pipe, Packs of 10 71400-15 Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	1 PK	\$12.34	\$12.34
27	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25 B134407 Country of Origin: Taiwan Schedule B #: 731822 ECCN #: EAR99 NLR	4 PK	\$6.66	\$26.64
	NOTE Tracking number(s) for this shipment: MFA004315586 MFA004315710			

SP15-A13